



Dart Aerospace Ltd.
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D2499**Job Sheet 190280****Part No:** D2499**Job Qty:** 6 pcs**Part Name:** Mounting Bracket**Part Weight:** 0 lbs**Status:** New**Priority:** Medium**Job Created:** 2/6/19**Job Tracking No:****Due Date:** 2/27/19**Created By:** Marie Lajeunesse**Type:** SOLD**Description:****Note:** DWG REV C IPP A 00.06.26 Removed P/O for powder coat EC IPP C Rev C dwg 07-09-25 DD verified by EC**Ship Via:****Bill of Materials****Job Routing**

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Bandsaw - 1	6 pcs		2/27/19	0.00	0.00	Bandsaw - 1		mar L 19/02/25
110	HAAS 4 Axis - B4B	6 pcs		2/27/19	0.00	0.00	HAAS - 1 - B4B		mar L 19/03/05
							HAAS - 2 - B4B		
							HAAS - 3 - B4B		
							HAAS - 4 - B4B		
120	QC 2	6 pcs		2/27/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 38		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		mar L 19/03/05
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 54		

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**Container No:** S159261**Part:** D2499**Job No:** 190280**Serial No/Batch:** S159261**Revision:****Inspector:****Exp Date:****Instructions:** Various STC's**Date:** 03/05/19

Plex 2/6/19 2:11 PM Dart.lajeunesse.marie

130 QC 8	6 pcs	2/27/19	0.00 0.00	QC 2 - 56	
				QC 2 - 57	
				QC 2 - 62	
				QC 2 - 63	
				QC 2 - 8	
				QC 2 - 66	
				QC 8 - 12	
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 38	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 47	
140 Handfinish - 1-1 Chemical-B4B	6 pcs	2/27/19	0.00 0.00	Handfinish - 1 - 1 - B4B	
				Handfinish - 1 - 2 - B4B	
				Handfinish - 1 - 3 - B4B	
				Handfinish - 1 - 4 - B4B	
				Handfinish - 1 - 5 - B4B	
				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	D.R. 19/03/06
				Handfinish - 1 - 11 - B4B	
				Handfinish - 1 - 12 - B4B	
				Handfinish - 1 - 13 - B4B	
				Handfinish - 1 - 14 - B4B	
				Handfinish - 1 - 15 - B4B	
				Handfinish - 1 - 16 - B4B	
				Handfinish - 1 - 17 - B4B	
				Handfinish - 1 - 18 - B4B	
				Handfinish - 1 - 19 - B4B	
				Handfinish - 1 - 20 - B4B	
				Handfinish - 1 - 21 - B4B	
				Handfinish - 1 - 22 -	

				B4B	
150	Powdercoat - 2 White GI(S)- B4B	6 pcs	2/27/19	0.00 0.00	Powdercoat - 1 - B4B
					Powdercoat - 2 - B4B
					Powdercoat - 3 - B4B
					Powdercoat - 4 - B4B
160	QC 3	6 pcs	2/27/19	0.00 0.00	QC 3 - 10
					QC 3 - 13
					QC 3 - 15
					QC 3 - 17
					QC 3 - 18
					QC 3 - 2
					QC 3 - 26
					QC 3 - 28
					QC 3 - 3
					QC 3 - 30
					QC 3 - 34
					QC 3 - 36
					QC 3 - 38
					QC 3 - 41
					QC 3 - 51
					QC 3 - 58
					QC 3 - 59
					QC 3 - 6
					QC 3 - 68
					QC 3 - 9
170	Packaging 3-1 - Stock - B4B	6 pcs	2/27/19	0.00 0.00	Packaging 3 - 1 - B4B
					Packaging 3 - 2 - B4B
					Packaging 3 - 3 - B4B
					Packaging 3 - 4 - B4B
					Packaging 3 - 5 - B4B
					Packaging 3 - 6 - B4B
					Packaging 3 - 7 - B4B
					Packaging 3 - 8 - B4B
					Packaging 3 - 9 - B4B
					Packaging 3 - 10 - B4B
					Packaging 3 - 11 - B4B
					Packaging 3 - 12 - B4B
					Packaging 3 - 13 - B4B
					Packaging 3 - 14 - B4B
					Packaging 3 - 15 - B4B
					Packaging 3 - 16 - B4B
					Packaging 3 - 17 - B4B
					Packaging 3 - 18 - B4B
					Packaging 3 - 19 - B4B
					Packaging 3 - 20 - B4B
					Packaging 3 - 21 - B4B
					Packaging 3 - 22 - B4B
					Packaging 3 - 23 - B4B
					Packaging 3 - 24 - B4B
					Packaging 3 - 25 - B4B
					Packaging 3 - 26 - B4B
					Packaging 3 - 27 - B4B
					Packaging 3 - 28 - B4B
					Packaging 3 - 29 - B4B
					Packaging 3 - 30 - B4B
					Packaging 3 - 31 - B4B
					Packaging 3 - 32 - B4B
					Packaging 3 - 33 - B4B
					Packaging 3 - 34 - B4B

BEB 19-03-06

DAS
40
9-89

MAR 07 2019

180 QC 21 - SA	6 pcs	2/27/19	0.00 0.00	Packaging 3 - 35 - B4B	One 21 MAR 07 2019
Part Op 100 - (Bandsaw)Cut blanks: 8.500" x 4.000" Descriptions: 110 - (HAAS CNC vertical machine #1)Machine as per folio D2499 120 - (QC2- Inspect parts off machine FAI/FAIB) 130 - (QC8- Inspect parts - second check) 140 - (Chemical Conversion Coat per QSI005 4.1) 150 - (White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum) *****mask slot as per dwg***** 160 - (QC3- Inspect Part Finish) 170 - (Identify as per dwg & Stock Location:_____) 180 - (QC21- Final Inspection - Work Order Release)					
START: 1:25 TEMP: 320° FINISH: 1:55					
Job BOM					
Part / Item	Component Name	Quantity	Operation	Container	
M6061T6B1.000X04.000	6061-T6 Bar 1.00 X 4.00	2.4000 ft (.4 ea)	100-Bandsaw - 1	5094297	
Job Allocations					
Operation	Component Part	Required	Inventory	Allocated	
100-Bandsaw - 1	M6061T6B1.000X04.000	2	82	0	
Part Specifications					
Specifications could not be found.					

MAT
used
2.137

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DART AEROSPACE LTD		Work Order:	190280
Description: Mount		Part Number:	D2499
Inspection Dwg: D2499 Rev: C		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.585	+/-0.010	0.581	✓		vern	mm L-05
1.252	+/-0.010	1.252	✓			
2.085	+/-0.010	2.084	✓			
3.585	+/-0.010	3.585	✓			
3.960	+/-0.010	3.958	✓			
0.375	+/-0.010	0.371	✓			
0.875	+/-0.010	0.872	✓		depth c	
1.500	+/-0.010	1.499	✓		vern	mm L-05
3.525	+/-0.010	3.525	✓		"	
4.150	+/-0.010	4.145	✓		Height G	3100 G
5.200	+/-0.010	5.200	✓		vern	mm L-05
3.460	+/-0.010	3.460	✓			
3.335	+/-0.010	3.335	✓			
2.541	+/-0.010	2.541	✓			
0.25	+/-0.010	0.248	✓			
5.700	+/-0.010	5.697	✓			
0.115	+/-0.010	0.113	✓		micr	mm L-01
0.770	+/-0.010	0.773	✓		vern	mm L-05
1.000	+/-0.010	0.997	✓			
0.25	+/-0.010	0.250	✓			
0.38	+/-0.010	0.380	✓			
0.250	+/-0.010	0.244	✓			
0.500	+/-0.010	0.502	✓			
R0.25	+/-0.010	.25	✓		Ab	
R0.50	+/-0.010	.500	✓		"	
R0.38	+/-0.010	.38	✓		"	
R0.13	+/-0.010	.13	✓		"	
R0.25	+/-0.010	.25	✓		"	
R0.06	+/-0.010	.060	✓		"	
Ø0.257	+0.006/-0.001	0.259	✓		vern	mm L-05
Ø0.386	+0.006/-0.001	0.389	✓		"	

Measured by: [Signature]		Audited by: [Signature]		Prototype Approval:		N/A
Date: 19/03/05		Date: 20/9/03/06		Date:		N/A
Rev	Date	Change	Revised by		Approved	
A	08.04.11	New Issue	KJ/DD [Signature]		[Signature]	